

Date: Friday, 21/12/2007 2:45:22 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MOUNTING ANGLE
Job Number :	36533		
Estimate Number :	10509		
P.O. Number :		Part Number :	D2564
This Issue :	21/12/2007	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2564 REV. B1
First Issue :	/ /	Project Number :	N/A
Previous Run :	35959	Drawing Revision :	B1
Written By :		Material :	
Checked & Approved By :		Due Date :	12/01/2008
Comment :	Est:D 02.09.09 Re-format; Added FA276 Folio KJ/RF		

Qty: 19 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6207	Angle Extrusion 1x1x.125
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Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s)
 Angle Extrusion
 Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)
 (D6207) Batch: 35960

20 08/02/19

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: B1 & Dwg D2564 Rev: B1

2-Deburr if necessary

20 08/02/19

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/02/19 (B)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

20 08/02/19

(19)

5.1 small fab.

GRIND RAPS

AS PER DWG

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/02
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MOUNTING ANGLE

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA*

08.02.20

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(5)

Comment: FINAL INSPECTION/W/O RELEASE

2008/02/20

Job Completion



u 08.02.20
[Signature]

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

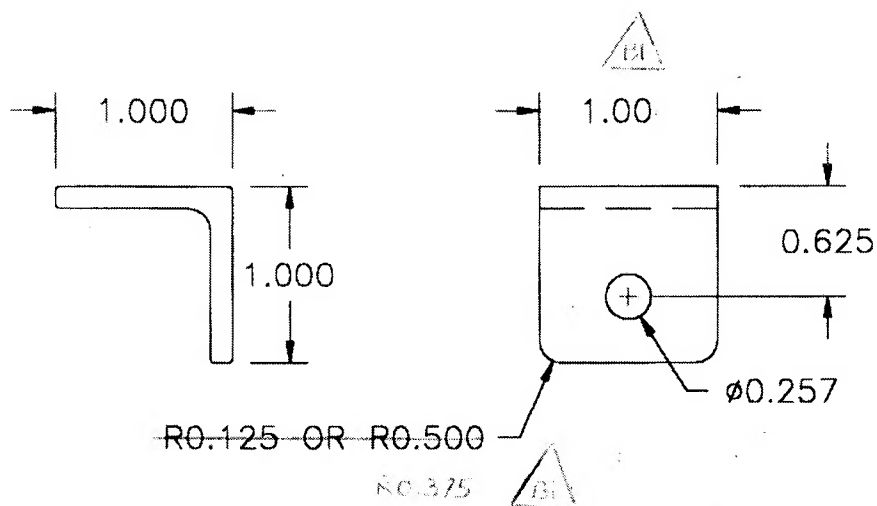
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN		DRAWN BY		DART AEROSPACE LTD	
MIKE M		MIKE M		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED		APPROVED		DRAWING NO.	REV. B
BW		BW		D2564	SHEET 1 OF 1
DATE			TITLE		
96:04:30			MOUNTING ANGLE		
B			97:05:06		
B			MODIFIED DIMENSIONS		
BI			4/17/97		
			R0.375 WAS R0.125 OR R0.500; 1.00 WAS 1.500		

RELEASED
97/05/06 BW



NOTES

- 1) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125
MAKE FROM D620/-XXX ANGLE EXTENSION
- 2) BREAK ALL SHARP EDGES 0.015 RADIUS
- 3) TOLERANCES PER DART 40103 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

4036533

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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